

303 R.750

## Work Order ID 114874

March-17-14 10:01:49 AM

Item ID: D2745

Revision ID:

Item Name: Bushing

Start Date: 3/17/14 Start Qty: 80.00

Required Date: 3/31/14 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: MJS

Date: 14-03-17

QC:

Date:

Sequence ID/  
Work Center IDOperation  
Description

Draw Nbr

Revision Nbr

D2745

Rev B

100

\*100\*

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-Turn as per Dwg D25152-Deburr

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

\*114874\*

Page 1

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Tooling:

Date:

SPC (Y/N):

Date:

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

DAS  
44  
9-89

14/03/20

80

0

0.00

0.00

DAS  
44  
9-89

14/03/20

80

0

0.00

0.00

0.00

DAS  
13  
9-89

80 0

14-3-21

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other    
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March-17-14 10:01:49 AM

Item ID: D2745

Revision ID:

Item Name: Bushing

Start Date: 3/17/14 Start Qty: 80.00

Required Date: 3/31/14 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Sequence ID/  
Work Center ID

130

\*130\*

Packaging

Packaging

Operation  
Description

Identify as per dwg & Stock Location: ST017

Memo

140

\*140\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

\*114874\*

Page 2

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Tooling:

Date:

SPC (Y/N):

Date:

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

0.00

0.00

0.00

80X DAS 28 14-03-21  
9-89

ML5 14-03-24

ML5 14-03-21

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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### FAULT CATEGORY

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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Picklist Print

March-17-14 10:01:55 AM

Page 1

Work Order ID: 114874

**\*114874\***

Parent Item: D2745

**\*D2745\***

Parent Item Name: Bushing

Start Date: 3/17/14

Required Date: 3/31/14

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP C02.03.07Update to turn in houseNG  
IPP Rev:D 07-10-23 Removed tumbling JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased		No		100	f	65.3110	0.0959	9			

\*\*

**\*M303R0 750\***

303 Round Bar 0.750

Location

Loc Qty

Loc Code

MAT028

65.311

65.311

m127464

127647

4'  
5' F.K 14/03/20

Could not pull mat'l!

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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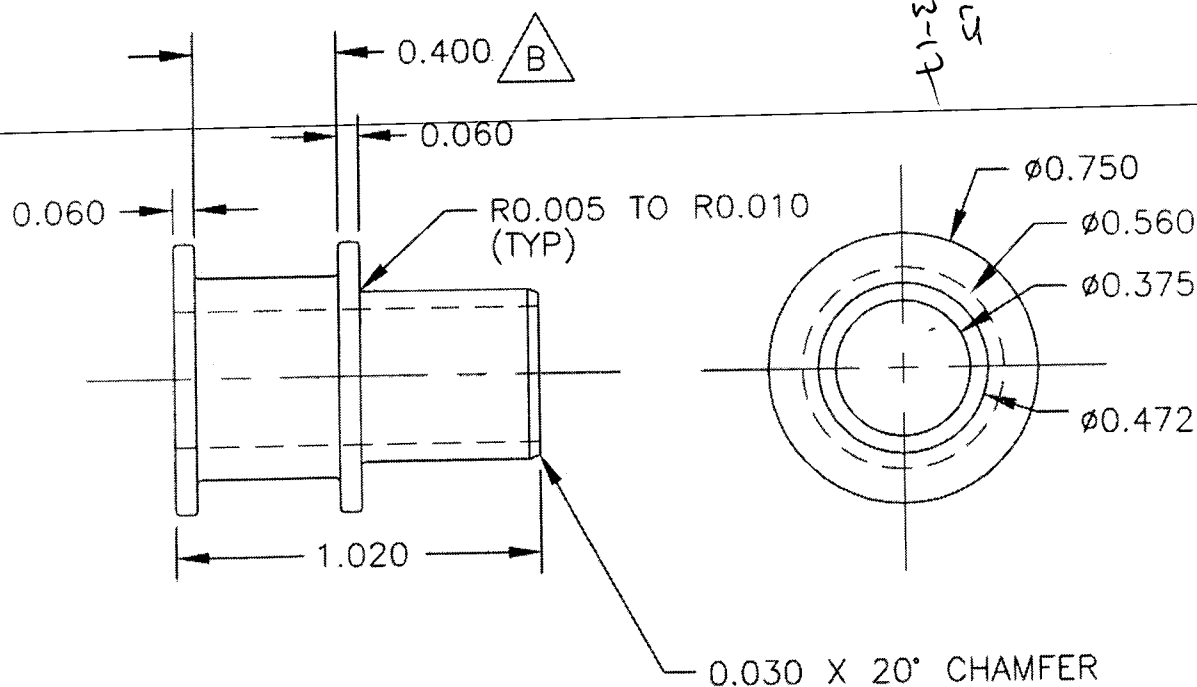






**DART**

DESIGN <i>DA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DA</i>	APPROVED <i>KE</i>	DRAWING NO. D2745	REV. B SHEET 1 OF 1
DATE 98.10.23		TITLE BUSHING	SCALE 2:1
A	98.04.16	NEW ISSUE	
B	98.10.23	DIM 0.400 WAS 0.380	

**RELEASED**  
98.11.03 DS

MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
RADIUS ALL INSIDE EDGES 0.005 TO 0.010  
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020  
ALL DIMENSIONS ARE IN INCHES